

Date: Thursday, 3/2/2006 3:07:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB		
Job Number	: 26027					
Estimate Number	: 10195					
P.O. Number	: N/A			Part Number	: D21741	
This Issue	: 3/2/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2174-1 REV. D	
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: N/A			Project Number	: N/A	
Written By	: <u>SAR</u> (Signature Below)			Drawing Revision	: D	
Checked & Approved By	: <u>OB</u> 03.02			Material	: N/A	
Comment	: Est C 04.06.09 Reformat KJ/RF			Due Date	: 3/25/2006	

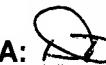
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	Batch: <u>M19059</u>
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: 12.75" x 4.83" Grain along 12.75"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA097 and Dwg D2174 Stack of 10 Identify as D2174-1	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

ml *06/03/22*

40

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5AD 06/04/02

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *220*

10/4/05 (40)

40

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/4/05 (40)

Job Completion



10/4/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26027
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	J.L	Prototype Approval:	N/A
Date:	06/03/18	Date:	06.03.18	Date:	N/A

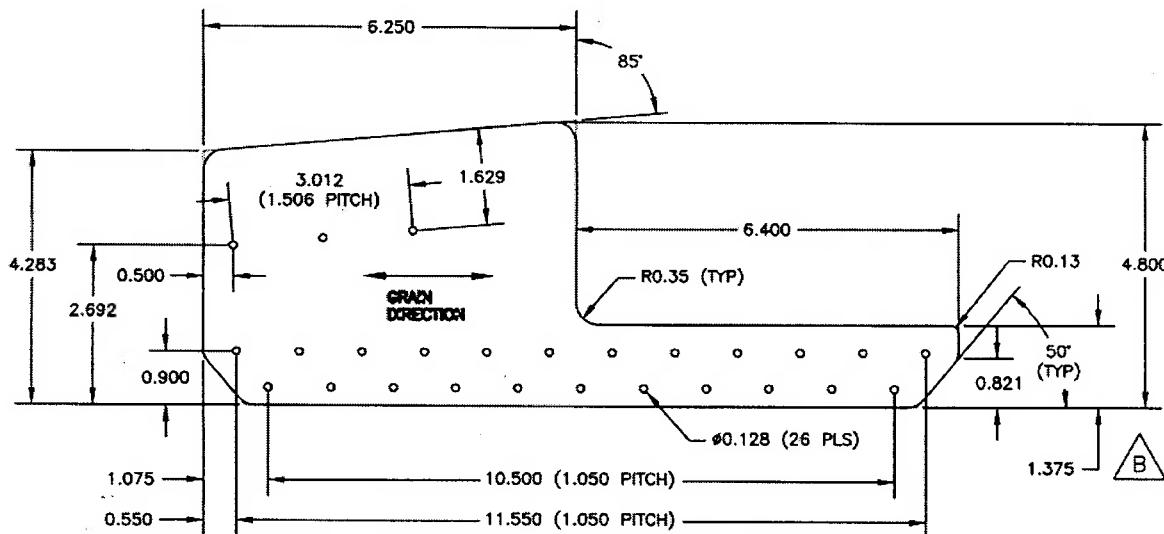
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	

RELEASED
04.06.04

DART

ACOPY
GEN

DESIGN REV.	DRAWN BY REV.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED H	APPROVED H	DRAWING NO. D2174-1	SHEET 1 OF 1
DATE 04.06.03	TITLE WEB	NEW ISSUE	SCALE 1:3
A	95.10.25	RE-DRAWN CHANGE DIMENSION	
B	96.01.18	UPDATE FINISH SPEC	
C	00.09.11		
D	04.06.03	RE-DESIGN	



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DIMENSION ARE IN INCHES

C

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WORK ORDER
NO. 26027

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